

Date: Wednesday, 10/31/2007 3:26:11 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 L WEB
Job Number	: 35476		
Estimate Number	: 11770		
P.O. Number	: N/A	Part Number	: D26545
This Issue	: 10/31/2007 S.O. No. N/A	Drawing Number	: D2654 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 30445	Material	: N/A
	Type : LANDING GEAR	Due Date	: 11/20/2007
Written By	:	Qty:	4 Um: Each
Checked & Approved By	:		
Comment	: Est Rev.D 99.02.04 Fixed typo, Changed procedure DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26007125	Extrusion 'I Beam' thick
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
: 1	D2600-7- 125	Web	B21966

SL ④ 7-11-6

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

SL 7-11-6 ④

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SL 7-11-6 x ④

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SL 7-11-7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/11/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:11 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 35476

Part Number: D26545

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07.11.07

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

BE 07.11.07

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/09

Job Completion



LG 07.11.08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

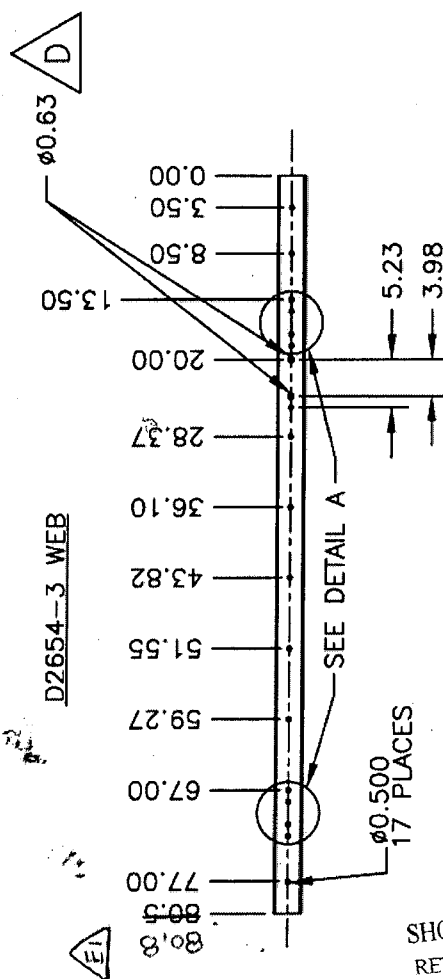
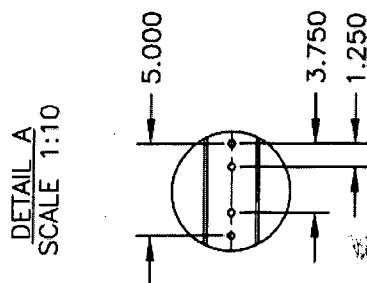
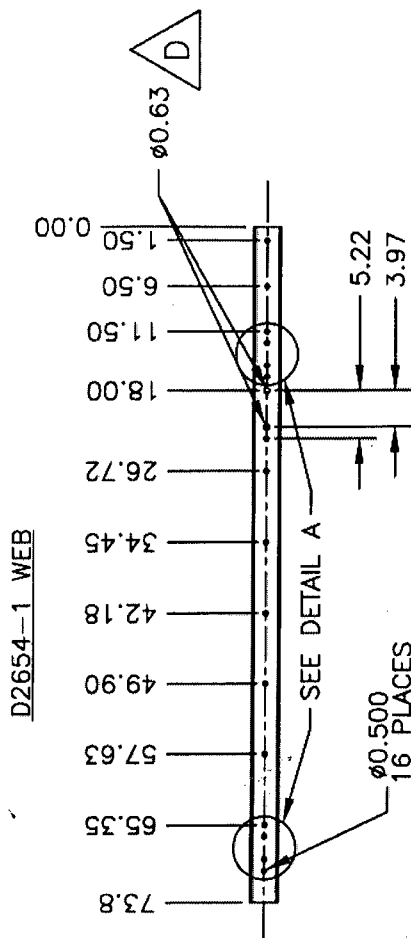
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1	<i>CP</i> 04.08.04	PER TOOLING; 80.8 WAS 80.5	

RELEASED
04.06.22

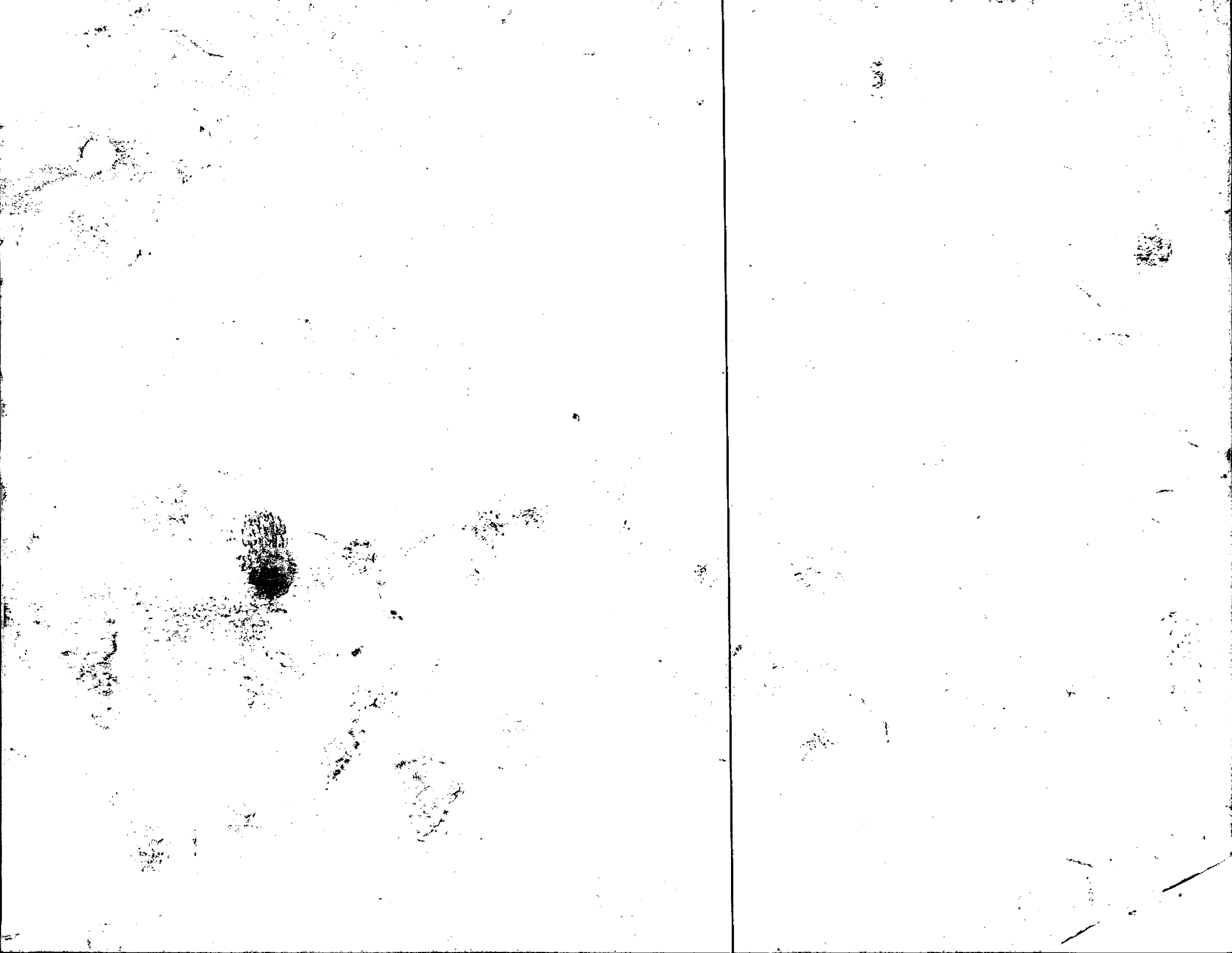


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NO. 35476

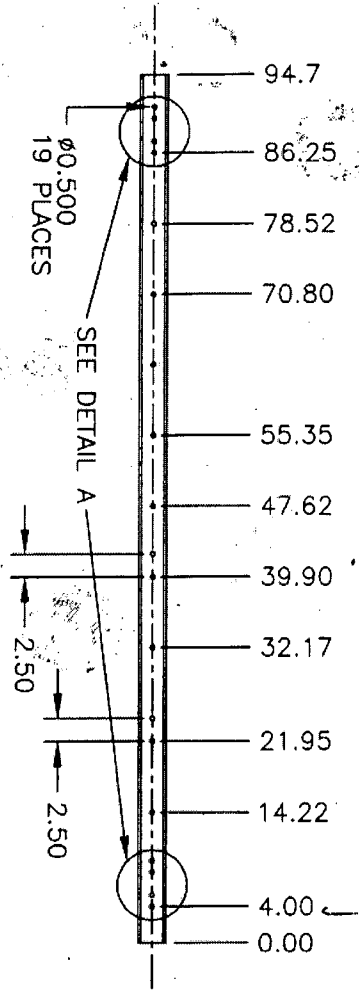
MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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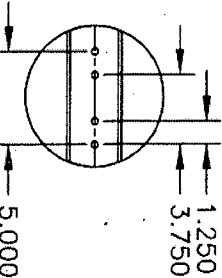
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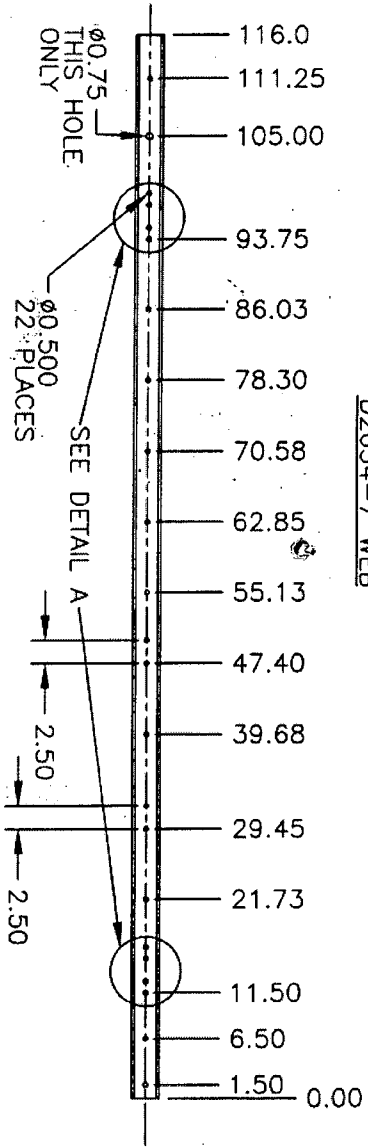
D2654-5 WEB



DETAIL A
SCALE 1:10



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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DESIGN	DRAWN BY	APPROVED	DATE	04.05.26
CHECKED	APPROVED	DRAWING NO.	TITLE	WEB
		D2654	SCALE	1:20
		SHEET 2 OF 2		
		REV. E		
		DART Aerospace USA, INC.		
		PORT HADLOCK, WA		



DART AEROSPACE LTD		Work Order: 35476
Description: Rear paw		Part Number: 2654-5
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 4.00	± 0.030	4.00				
B 14.22	± 0.030	14.22				
C 21.95	± 0.030	21.95				
D 32.17	± 0.030	32.17				
E 39.90	± 0.030	39.90				
F 47.62	± 0.030	47.62				
G 55.35	± 0.030	55.35				
H 70.80	± 0.030	70.80				
I 78.52	± 0.030	78.52				
J 86.25	± 0.030	86.25				
K 94.7	± 0.100	94.7				
L						
M						
N Detail A						
O						
P 1.250	± 0.010	1.250				
Q 3.750	± 0.010	3.750				
R 5.000	± 0.010	5.000				
S						
T						
U						
V						
W						
X						
Y						

Measured by: SL	Audited by: <i>[Signature]</i>	Prototype Approval: <i>[Signature]</i>
Date: 7-11-2	Date: 07-11-05	Date: 07-11-05

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

